

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017982**Date Inspected:** 26-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|--------------|----------------------------------|---------------|----|
| CWI Name: | An Qing Xing | CWI Present: | Yes | No |
| Inspected CWI report: | Yes No N/A | Rod Oven in Use: | Yes No N/A | |
| Electrode to specification: | Yes No N/A | Weld Procedures Followed: | Yes No N/A | |
| Qualified Welders: | Yes No N/A | Verified Joint Fit-up: | Yes No N/A | |
| Approved Drawings: | Yes No N/A | Approved WPS: | Yes No N/A | |
| | | Delayed / Cancelled: | Yes No N/A | |
| Bridge No: | 34-0006 | Component: | OBG COMPONENT | |

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG segment 11BW to 11CW, weld No.OBW11-009. The welder is identified as #042218. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-1.

SAW in the 1G position for the OBG segment 11BE to 11CE, weld No.OBE11-008. The welder is identified as #040460. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-1.

FCAW in the 2G position for the OBG segment 11BE, weld No.SEG068A-046. The welder is identified as #040367. ZPMC QC is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

Bay#16

This QA Inspector observed the following work in progress:

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FCAW in the 2F position for the OBG steel Barrier, weld No.W5-SB1-042-112~114. The welder is identified as #201888. ZPMC QC is identified as Mr. Guo Pan.The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG suspender bracket SB106W, weld No.SB022-106-003. The welder is identified as #260562. ABF QA is identified as Mr. Peng Wen Jun.The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW in the 1G position for the OBG suspender bracket SB104W, weld No.SB022-104-003. The welder is identified as #062752. ABF QA is identified as Mr. Peng Wen Jun.The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

Bay#9

This QA Inspector observed the following work in progress:

During random visual inspection at bay #9 the QA inspector observed that the ABF QA Mr.Kag Yi and ZPMC QC Mr. Chen Shi Gang performing Visual inspection at service platform weld joints.

The component is identified as SPB8-2 and SPB8-3.

Ultrasonic Testing (UT) for Floor Beam

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG floor beam weld joints.

The welds designation reviewed are as follows:

FB3273-001-016,009,008,017,005,056,054,053

FB3272-001-005,008,016,025,058,046,041,018,017,009,015,035,053,052,028,001

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer